

Date: Wednesday, 14/01/2009 8:35:07 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 SADDLE
Job Number : 44636	
Estimate Number : 12451	
P.O. Number :	Part Number : D35001
This Issue : 14/01/2009 S.O. No. :	Drawing Number : D3500 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 43423	Material :
Written By :	Due Date : 30/01/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 09.01.14</u>	
Comment : Est Rev:A New Issue 06-06-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6102013	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

6061-T6 7.0x6.5x2.0

350 Saddle Billet

Batch: 343918

DJP 09/01/22 (10)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1Program Batch No. 44636 Double check by: HA

1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets

4-Deburr

5-Tumble to remove sharp edges.

DJP 09/01/22 (10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

DJP 09/01/22 (10)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

J.L 09/01/25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3500-1 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 09/02/02
 Resolution: _____ Disposition: ✓ QA: N/C Closed: _____ Date: _____

NCR: <u>44636</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.01.23	2	WALL THICKNESS UP TO 0.166 IN SOME AREAS. DIST TO FIRST SKID HOLE (1" F") IS 0.488" ON ONE SIDE. First part	<u>CP</u> 09.01.23 per QSI 042	PART OK. Addition thickness OK. Hole Pattern CORRECT. Hole location 0.002" UNDER TOL BECAUSE PART WIDTH AT LOWER TOL.	<u>DTP</u> 09/01/23	<u>SS</u> 09/01/26.	<u>CP</u> 09.01.23 per QSI 042	<u>S</u> 09/01/26

NOTE: Date & initial all entries

Date: Wednesday, 14/01/2009 8:35:07 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 44636

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 09/01/26

10

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 109996

START TIME:

7:45

OVEN TEMPERATURE:

320°

FINISH TIME:

8:15

BR 09-01-29

10

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-01-29

10

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 429

9/1/29

10

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/02

Job Completion



MF 09-01-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>K4636</u>
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

Dim	Min	Max	Go/No. Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.483	0.490		0.487	0.487	0.487	0.487		
B	1.175	1.185		1.178	1.178	1.178	1.178		
C	3.145	3.155		3.147	3.147	3.147	3.147		
D	1.175	1.185		1.178	1.178	1.178	1.178		
E	0.365	0.385		0.370	0.370	0.370	0.370		
F	0.490	0.510		0.497	0.490	0.497	0.495		
H									
I	R1.575	R1.595		1.583	1.584	1.586	1.586		
J	0.240	0.260		0.247	0.2455	0.2475	0.247		
K	0.490	0.510		0.497	0.497	0.497	0.497		
L	3.590	3.650		3.615	3.615	3.615	3.615		
M	0.315	0.322		0.321	0.321	0.321	0.321		
N	0.256	0.262		0.260	0.260	0.260	0.260		
O	6.500	6.520		6.505	6.505	6.506	6.506		
P	5.990	6.010		5.9855	5.9855	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.498	2.499	2.499	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.545	0.546	0.548	0.548		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.102	0.102	0.102		
AA	R1.125	R1.145		1.131	1.132	1.1315	1.132		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.260	0.257	0.260	0.256		
AE	1.810	1.830		1.822	1.821	1.822	1.821		
AF	0.240	0.260		0.250	0.250	0.250	0.248		
AG	0.140	0.160		0.150	0.150	0.150	0.148		
AH	0.140	0.160		0.160	0.155	0.156	0.155		
AI	0.140	0.160		0.160	0.157	0.155	0.154		
Accept/Reject									

Measured by: <u>DTP</u>
Date: <u>09/01/22</u>

Audited by: <u>J.L</u>
Date: <u>09/01/25</u>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

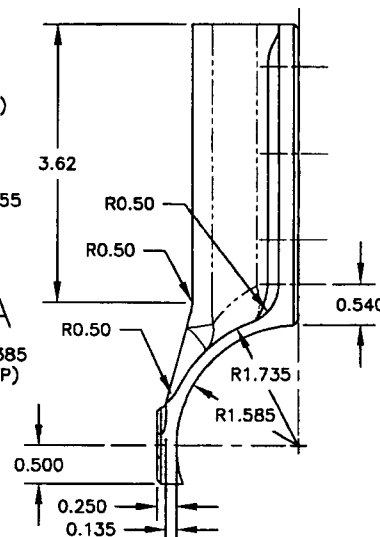
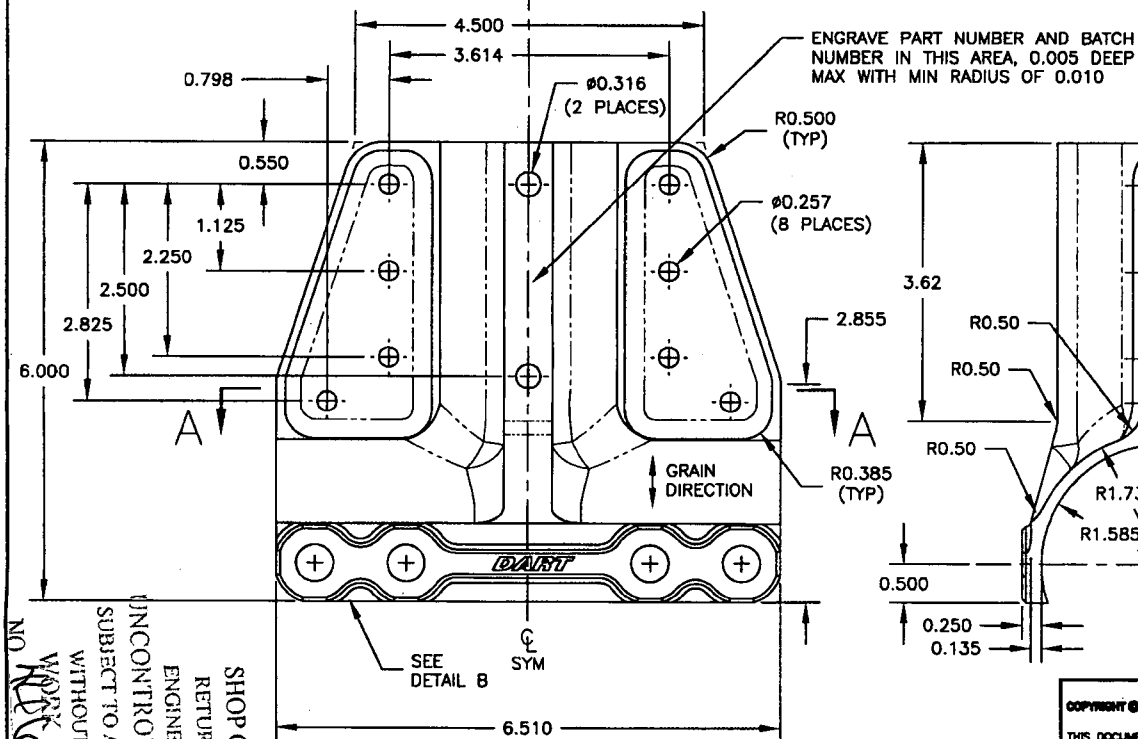
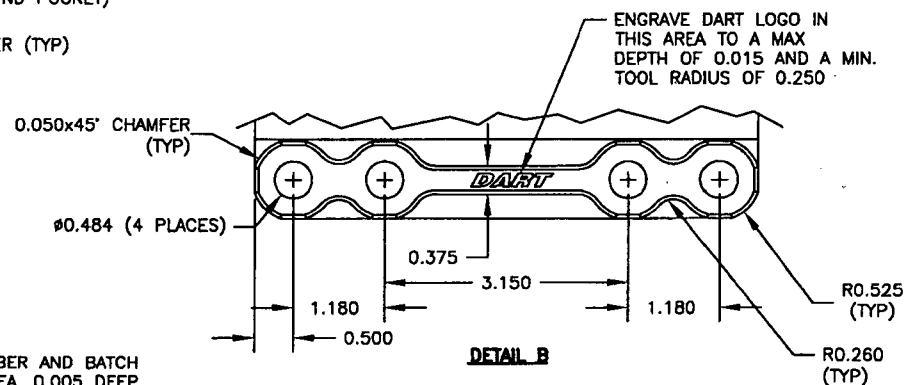
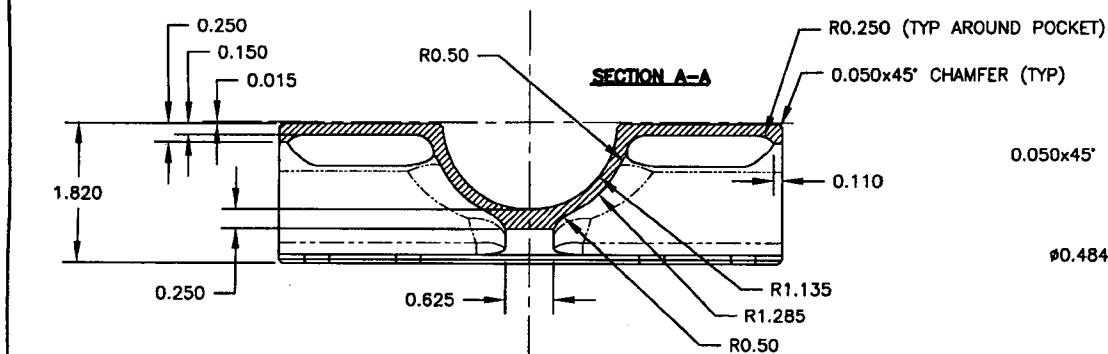
DART AEROSPACE LTD		Work Order:	44630
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.483	0.490		0.487	0.487	0.487	0.487		
B	1.175	1.185		1.179	1.178	1.178	1.178		
C	3.145	3.155		3.148	3.148	3.149	3.148		
D	1.175	1.185		1.178	1.178	1.179	1.178		
E	0.365	0.385		0.370	0.370	0.370	0.370		
F	0.490	0.510		0.495	0.495	0.497	0.497		
H									
I	R1.575	R1.595		1.586	1.585	1.586	1.586		
J	0.240	0.260		0.244	0.244	0.244	0.246		
K	0.490	0.510		0.497	0.497	0.497	0.497		
L	3.590	3.650		3.615	3.615	3.615	3.620		
M	0.315	0.322		0.321	0.321	0.321	0.321		
N	0.256	0.262		0.260	0.260	0.260	0.260		
O	6.500	6.520		6.515	6.510	6.510	6.510		
P	5.990	6.010		6.000	5.997	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.5465	0.546	0.546	0.545		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.102	0.102	0.102	0.102		
AA	R1.125	R1.145		1.132	1.130	1.132	1.132		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.245	0.255	0.255	0.255		
AE	1.810	1.830		1.819	1.818	1.818	1.818		
AF	0.240	0.260		0.2475	0.247	0.248	0.248		
AG	0.140	0.160		0.1425	0.147	0.148	0.148		
AH	0.140	0.160		0.153	0.156	0.155	0.155		
AI	0.140	0.160		0.154	0.155	0.155	0.155		
Accept/Reject									

Measured by:	DJP
Date:	09/01/23

Audited by:	JL
Date:	09/01/25

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	/
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/B OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06-08-15 #

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C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	GP	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	06.06.30	TITLE SADDLE
		DART AEROSPACE LTD. HAMMERSLEY, OXFORD, CHAMPA
		DRAWING NO. D3500
		REV. C
		SHEET 1 OF 1
		SCALE 2:3